

Date: Friday, 18/05/2007 9:45:22 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : MODIFY TO CHG003
Job Number : 32442	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D206642541
This Issue : 18/05/2007 S.O. No. : <i>N/A</i>	Drawing Number : D206642541
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>N/A</i>
Previous Run : 32441	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 25/05/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

*chg003*

①

Comment: HAND FINISHING RESOURCE #1

REMOVE FROM STOCK

✓ D206-642-511 B *26682**m-h 07/05/31*

2.0	D206642511	Float Skidtube LH
-----	------------	-------------------



①

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Float Skidtube LH

m-h 07/05/31

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



①

Comment: HAND FINISHING RESOURCE #1

REMOVE STEEL WEARPLATES AND SIKAFLEX

m-h 07/05/31

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

FA05-31 ①

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

REPAINT IF NECESSARY

NIA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/05/2007 9:45:23 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: MODIFY TO CHG003

Job Number: 32442

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MAJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

QC5

INSPECT WORK TO CURRENT STEP



7.05.31.0



Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts

8.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

BOLT

Batch:

M104291

9.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B31990

10.0

D353523

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B30760 32349

11.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B31992

12.0

D353539

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B30752

M.L 07/05/31

**①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/05/2007 9:45:23 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: MODIFY TO CHG003

Job Number: 32442

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	D353615	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B 30753

14.0	D353623	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B 30754

15.0	D353635	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B 31996

16.0	D353639	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B 30756

17.0	D35371	WEARPAD
------	--------	---------



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

WEARPAD

Batch:

B 31998

18.0	D35373	WEARPAD
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD

Batch:

B 32071 M-L installed 07/06/04 ①
not installed *
missing 07/06/01 M-L

19.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number
80 AN960C10L

Description Batch
Washer M104215

M102602

(44X)

①

(36X)

M-L 07/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/05/2007 9:45:23 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: MODIFY TO CHG003

Job Number: 32442

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



①

Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

Sikaflex expire date:

M103561
07-10

M-L 07/06/01

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch:

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20706-06 @

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE USING NEW B/N

NEW PAPERWORK AND LABELS REQ'D

CHG 003

REV B

P 7/6/7

① SEP

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207106/08

2070608

Job Completion



DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-541	CHG	CHG002
DESC	Replacement Skidtube	STC	SH98-4
LOT	B26682	STC	SA00475SE
MODEL	Bell 206L/L1/L3/L4/407	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

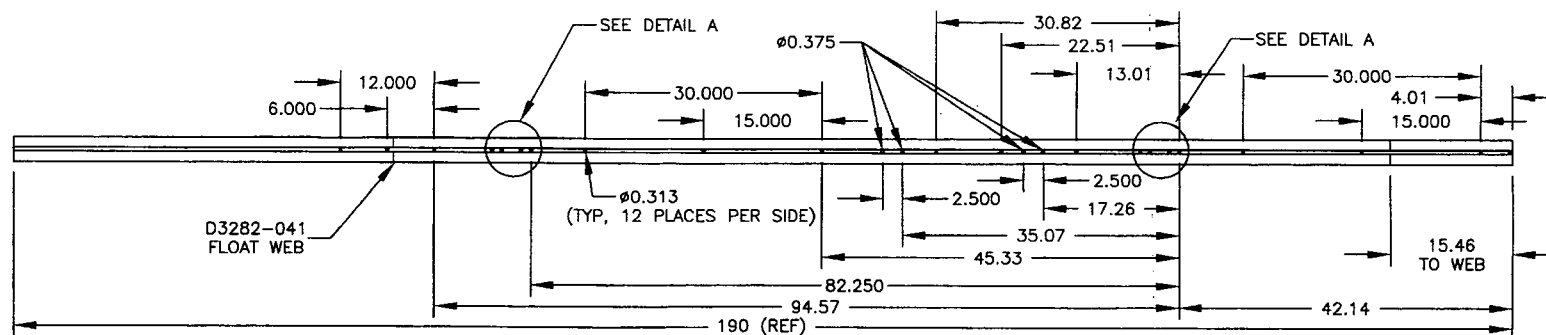
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

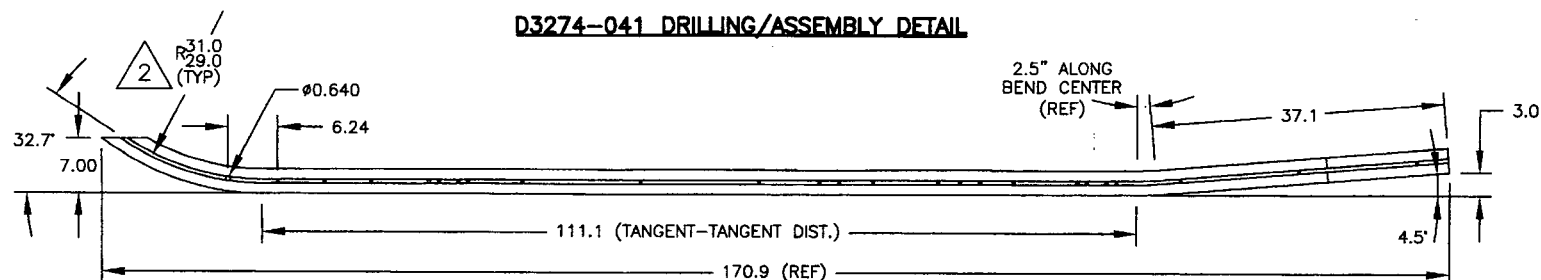
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

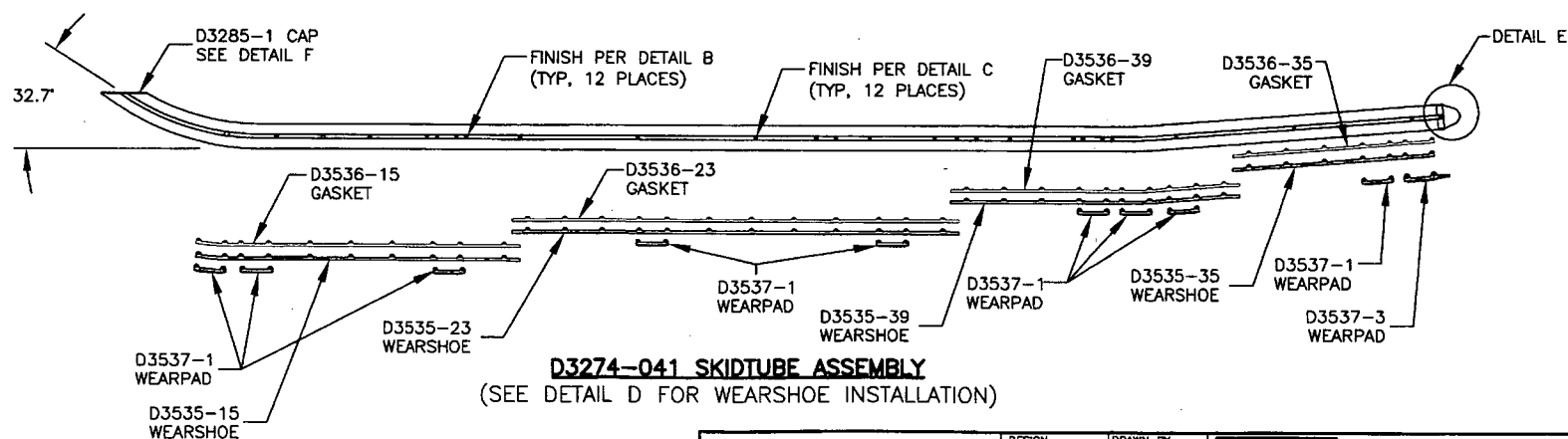
NOTE: Date & initial all entries



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

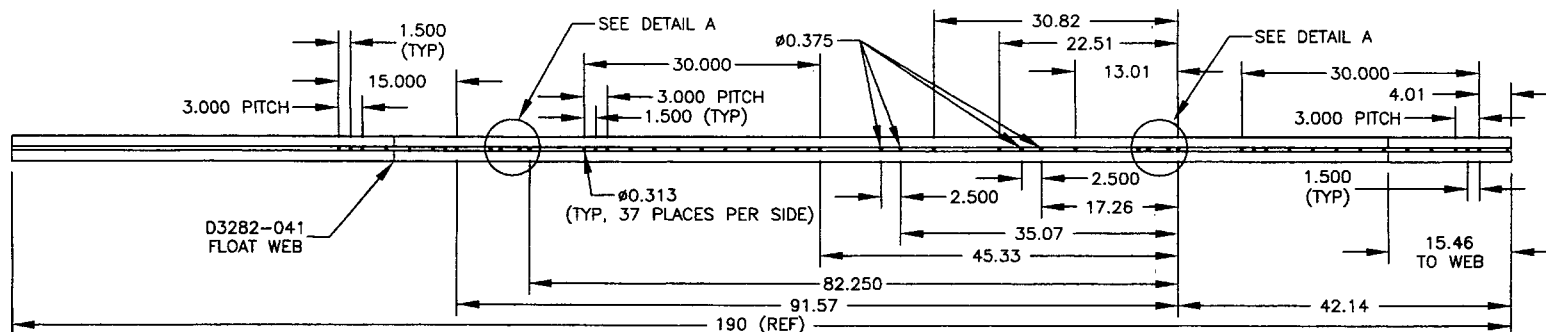
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

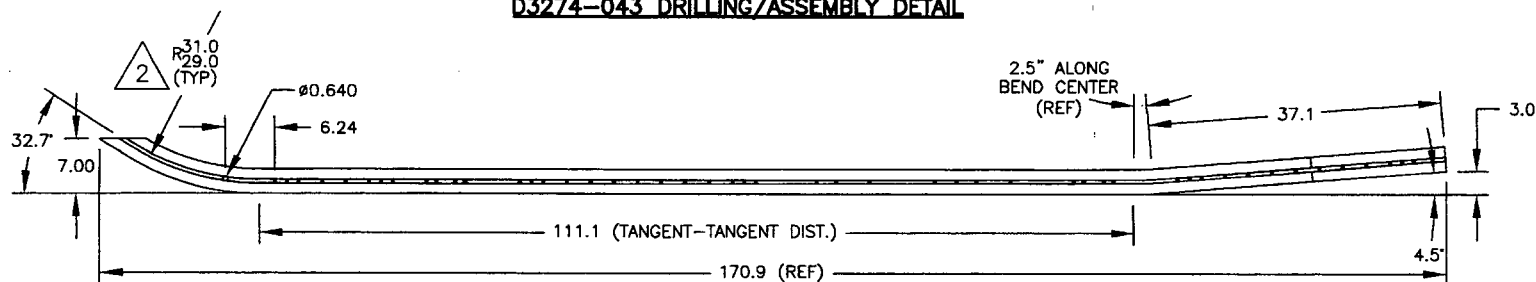
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

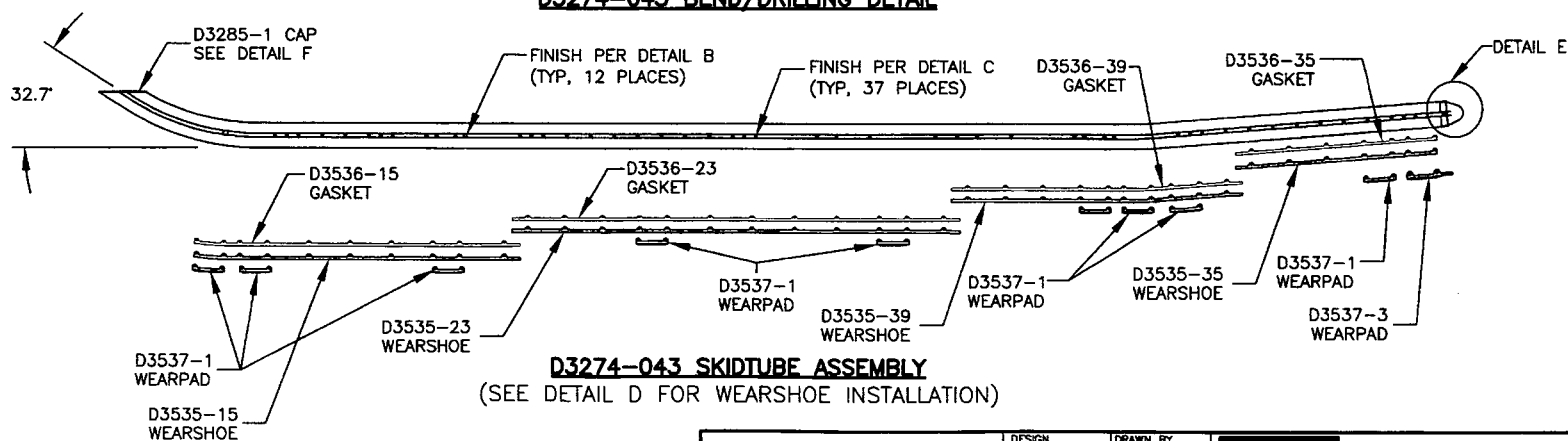
NOTE: Date & initial all entries



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.		DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED	#	APPROVED	#	DRAWING NO.	D3274
		DATE	06.12.19	TITLE		SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

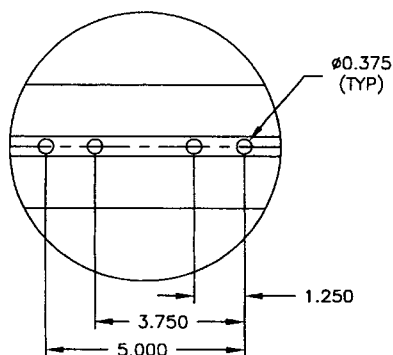
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

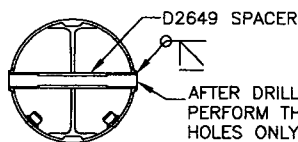
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

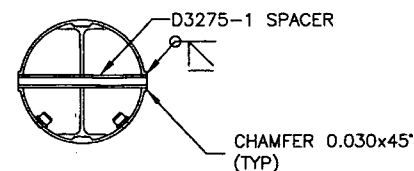


DETAIL B FOR 0.375 HOLES ONLY

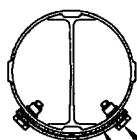


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



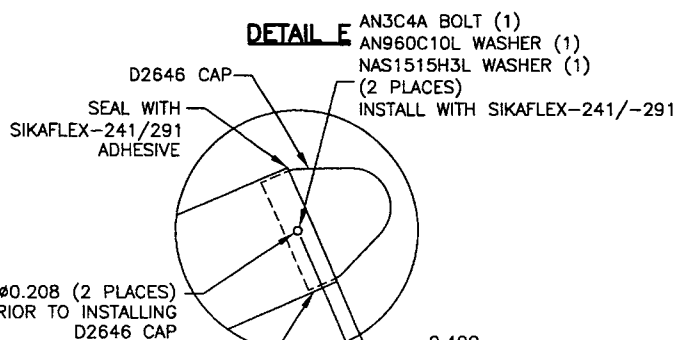
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

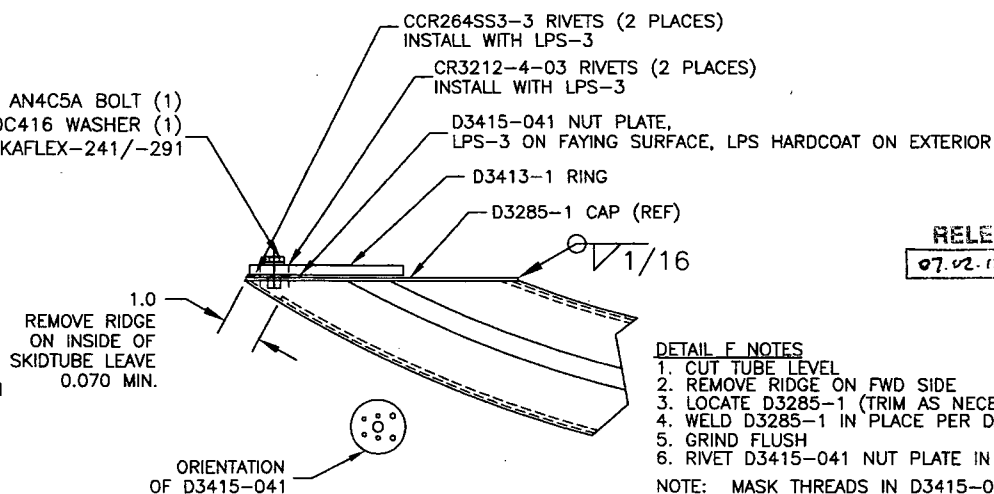
DETAIL E



0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
07.02.12

COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.		DESIGN CP	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED H	APPROVED H	DRAWING NO. D3274	REV. D SHEET 4 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

21

Date: Wednesday, 5/23/2007 3:10:07 PM
User: Kim Johnston

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: MODIFY TO CHG003
Job Number	: 32442		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206642541
This Issue	: 5/23/2007 S.O. No. :	Drawing Number	: D206642541
Prsht Rev.	: NC	Project Number	:
First Issue	: 5/18/2007 Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 32441	Material	:
Written By	:	Due Date	: 5/25/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



07.05.25

Seq. #: Machine Or Operation Description :

1.0 HAND FINISHING HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REMOVE FROM STOCK

D206-642-511 B _____

2.0 D206642511 Float Skidtube LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Float Skidtube LH

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REMOVE STEEL WEARPLATES AND SIKAFLEX

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

REPAINT IF NECESSARY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries